Qty:

De 07/05/30 Seep J. Con Details.

Each

4 Um:

: WINDOW ASSEMBLY

: D3136043

: 10/06/2007

: N/A

: D3136 REV D

Date:

Monday, 28/05/2007 2:23:18 PM

User:

Linda Lacelle

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**

: 32272B : 10304

P.O. Number

: NIA

This Issue

: 28/05/2007

Prsht Rev. : NC

First Issue

: 10/05/2007

Type

S.O. No. : NA

Previous Run : 29383B

Written By

Checked & Approved By

Comment

: MACHINED PARTS

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: THERMOFORMING MACHINE

1.0

THERMOFORMING

Comment: THERMOFORMING MACHINE

MAKE AS PER DRWG

D3136 REV.D

MACRLICS125

1/8" Polycast II Sheet

INSPECT WORK TO



Comment: Qty.:

4.4700 sf(s)/Unit Total:

17.8800 sf(s)

1/8" Polycast II Sheet

3.0

2.0

QC5



Comment: INSPECT WORK TO CURRENT STEP

4.0

Decal



Comment: Qty.:

2.0000 Each(s)/Unit

Total:

8.0000 Each(s)

Pick:

Qty Part#

Description

Decal

B 22608

M. 07/05/31

5.0

SMALL FAB

SMALL & MEDIUM FAB RESOURCE 1



D3108-9

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Trim back masking film as per Dwg D3136 and apply D3108-9 decals to inside surface of windows.

2-Engrave Part number and Batch number as per Dwg D3136

Dåte: Monday, 28/05/2007 2:23:18 PM Linda Lacelle User: **Process Sheet Drawing Name: WINDOW ASSEMBLY** Customer: CU-DAR001 Dart Helicopters Services Part Number: D3136043 Job Number: 32272B Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP 6.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion 1.1.) TRIM BLANKS 4 pures 26.75" x 21,5" M. 103735 MACRYCIC .105" 1.2) FORM AS Per Duc 3136 Rev. D. 14 07/05/30 1.2) FORM AS POR DENS 3136 RED.D. 14.07/05/30 FOLIO FTA 002. 1.3) FINISH TRIM AND POLISH EDGES 15,07/05/21 4) Pick LABELS B22608 Dt. 07/05/31
5) lagrane Portrumber + Botch, Apply LABELS 18h 07/05/31
Rework, I window 07/06/20 Dt.

Dart Aerospace Ltd. Thursday, 5/10/2007 2:24:14 PM Kim Johnston User **Process Sheet** : WINDOW ASSEMBLY **Drawing Name** Customer : CU-DAR001 Dart Helicopters Services Job Number : 32272B : 10304 **Estimate Number** Part Number : D3136043 P.O. Number : D3136 REV D **Drawing Number** : 5/10/2007 S.O. No. : This Issue : N/A : NC Project Number Prsht Rev. : D : MACHINED PARTS : // **Drawing Revision** Type First Issue : 29383B **Material** Previous Run Each **Due Date** : 6/10/2007 Qty: 4 Um: Written By Checked & Approved By New issue KJ/DS : Est R 04.02.04 Comment **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: PURCHASING 1.0 Comment: PURCHASING Issue P/O: Order D3136-3 per Dwg D3136 Supplier: -Canus Fabricate as per Dwg D3136 Apply 3M Protective Masking Film on top side only as per Dwg D3136 Material release note required WINDOW 2.0 D31363 Comment: Qty.: 4.000Q Each(s) 1.0000 Each(s)/Unit Total: **WINDOW** G RESOURCE #1 3.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached 4.0 DIMENSIONAL CHECK QC6 Comment: DIMENSIONAL CHECK Decal 5.0 D31089

Page 1

Comment: Qty.:

Pick:

Qty

Part#

D3108-9

2.0000 Each(s)/Unit

Description

Decal

Total:

Batch

8.0000 Each(s)

Dart Ae	rospace	Ltd						
W/O:			WC	RK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					:			
	:							
Part No	:	PAR #:	Fault Cateo	Jory:	_ NCR: Yes	No DQA:	Date: _	
					QA: N	C Closed:	Date: _	
NCR:	المرابع	·	WORK ORDE	R NON-CONFORMA	ANCE (NCR)		
		Description of NC		Corrective Action Secti	ion B	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
							1	

		Description of NC Section A		Corrective Action Section B				
DATE	STEP		Initial Action Description S Chief Eng		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
-								

NOTE: Date & initial all entries

Date: User: Thursday, 5/10/2007 2:24:14 PM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW ASSEMBLY

Job Number: 32272B

Seq. #:

Job Number:

Machine Or Operation:

Description:

Part Number: D3136043

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Trim back masking film as per Dwg D3136 and apply D3108-9 decals to inside surface of windows.

2-Engrave Part number and Batch number as per Dwg D3136

7.0

QC5

INSPECT WORK TO CURRENT STEP

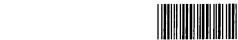


Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

QC21

9.0

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		\	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE C	HANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector	
		•							
Part No	:	PAR #: Fault Ca	ategory:	NCR: Ye	s No DQ	A:	Date: _		
				QA	: N/C Close	d:	_ Date: _		

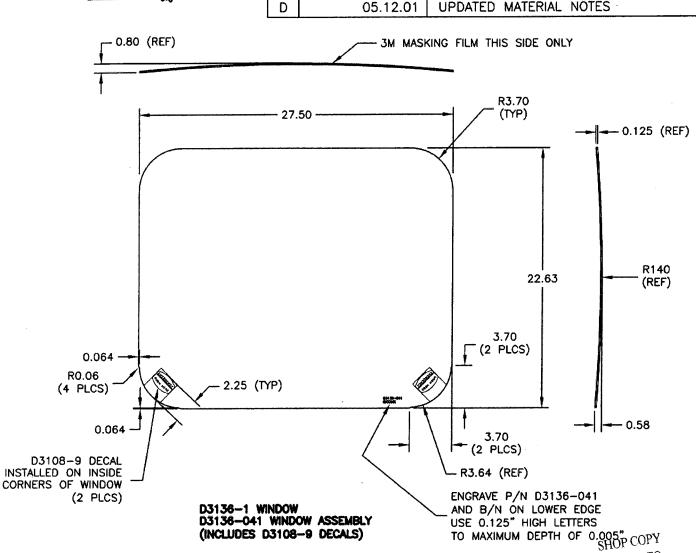
	WORK ORDER NON-CONFORMANCE (NCR)								
STEP	Description of NC	Corrective Action Section B			Verification	Annroval	Approval		
	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Initial Action Description Sign & Verification Section C Chief Eng		

NOTE: Date & initial all entries



DESIGN		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECI	KED "II	APPROVED	DRAWING NO. REV. D				
·	献	#	D3136 SHEET 1 OF 2				
DATE			TITLE SCALE				
05.1	12.01		WINDOW ASSEMBLY 1:8				
Α		02.04.18	NEW ISSUE				
В		04.01.21	ADDED D3136-3 AND D3136-043				
С		04.05.05	ADDED FORMING & ENGRAVING SPEC				





ENGINEERING

RETURN TO

1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET FER MIL-P-5425 OR PLEXIGLAS G TINCO TROLLED COPY

CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
SUBJECT TO AMENDMENT

2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F WITHOUT NOTICE

b) DRAPE OVER D3136-T1 MOLD & CLAMP

c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

d) TRIM PER TEMPLATE D3136-1T2

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

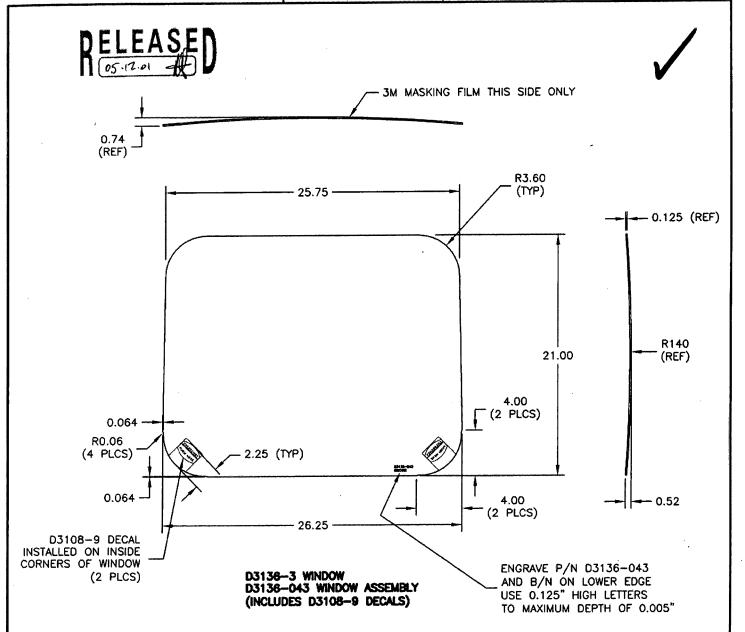
4) ALL DIMENSIONS ARE IN INCHES

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1	DESIGN ##	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
	CHECKED	APPROVED,	DRAWING NO. D3136	REV. D SHEET 2 OF 2			
į	DATE		TITLE	SCALE			
1	05.12.01		WINDOW ASSEMBLY	1:8			



SHOP COPY NOTES: CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICKRET DE L'ARCERS COLLEGE TO COLLEGE T 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET FER MIL-P-5425 OR PLEXIGLAS G ENGINEERING

2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F

c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS TO AMENDMENT OF TEMPLATE D3136-311 WITHOUT NOTICE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

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